

Date: Tuesday, 26/06/2007 8:39:56 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR WINDOW		
Job Number	33123	Part Number	: D3295041		
Estimate-Number	10848	Drawing Number	: D3295 REV C		
P.O. Number	N/A	Project Number	: N/A		
This Issue	26/06/2007	S.O. No.	: N/A		
Prsht Rev.	NC	Drawing Revision	: C		
First Issue	N/A	Material	: N/A		
Previous Run	33123	Due Date	: 12/07/2007 Qty: 20 Um: Each		
Written By	<u>L</u>				
Checked & Approved By					
Comment	Est. C 05.06.20 D3295-1 no longer made in-house KJ/JLM Est Rev:D Added DT8822 07-03-20 JLM Est Rev:E Returned Manufacturing In House 07-06-26 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MACRLICS125	1/8" Polycast II Sheet M103735 X 12 M17616 X 2 1/8" Polycast-II Sheet Comment: Qty.: 1.3020 sf(s)/Unit Total : 26.0400 sf(s) M104596 X 7 1B07-10-17
2.0	SHEAR	SHEAR 1B07-10-17 Comment: SHEAR Cut Blanks 17.250" X 10.500"
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 1B07-10-18 Comment: HAAS CNC VERTICAL MACHINING #1
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 1B07-10-17/Just Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK 1B07-10-18 Comment: SECOND CHECK
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 1B07-10-18 Comment: SMALL & MEDIUM FAB RESOURCE 1 Debur if necessary

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 33123

Part Number: D3295041

Job Number:



Seq. #:	Machine Or Operation:	Description :
7.0	D27281	Dart Logo label small
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Dart Logo label small Assemble as per Dwg D3295. Put window in plastic wrap. Pick: Qty Part Number Description Batch 1 D2728-1 Decal b24215 mf 07-10-18</p>		
8.0	QC5	INSPECT WORK TO CURRENT STEP
9.0	PACKAGING 1	PACKAGING RESOURCE #1
10.0	QC21	FINAL INSPECTION/W/O RELEASE

Job Completion



W 07.10.09

Date: Monday, 6/25/2007 9:10:43 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FLOOR WINDOW		
Job Number	33123		Part Number	D3295041		
Estimate Number	10848		Drawing Number	D3295 REV C		
P.O. Number	:		Project Number	N/A		
This Issue	6/25/2007	S.O. No. :	Drawing Revision	C		
Prsht Rev.	NC		Material	:		
First Issue	11	Type : PURCHASED PARTS	Due Date	7/12/2007	Qty:	20
Previous Run	32689		Um:	Each		
Written By	:					
Checked & Approved By	:					
Comment	Est. C 05.06.20 D3295-1 no longer made in-house KJ/JL M Est Rev:D Added DT8822 07-03-20 JLM					

Additional Product

W2 Verjet?
Haas?

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: _____ Fabricate D3295-1 as per Dwg D3295 Possible Supplier: Canus Material releas note is required		
1.2		
2.0	D32951	Window
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Window Pick: Qty Part Number Description Batch 1 D3295-1 Window _____		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK AS PER DT8822 TEMPLATE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/19	#20	one window screen small cut out from wake set.	D action	Scrap and Destroy Fix Program	BB 07-10 -19	G	KB 07/10/19	CS 07/10/19
07/10/19	#1	Two small (blemishes found, Polish out)	D action	Polish out one could not be removed Scrap	Dh. 07/10/19	G	D 07/10/19	CS 07/10/19

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 33123

Part Number: D3295041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

6.0 D27281 Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Dart Logo label small

Assemble as per Dwg D3295.

Put window in plastic wrap.

Pick:

Qty	Part Number	Description	Batch
1	D2728-1	Decal	

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

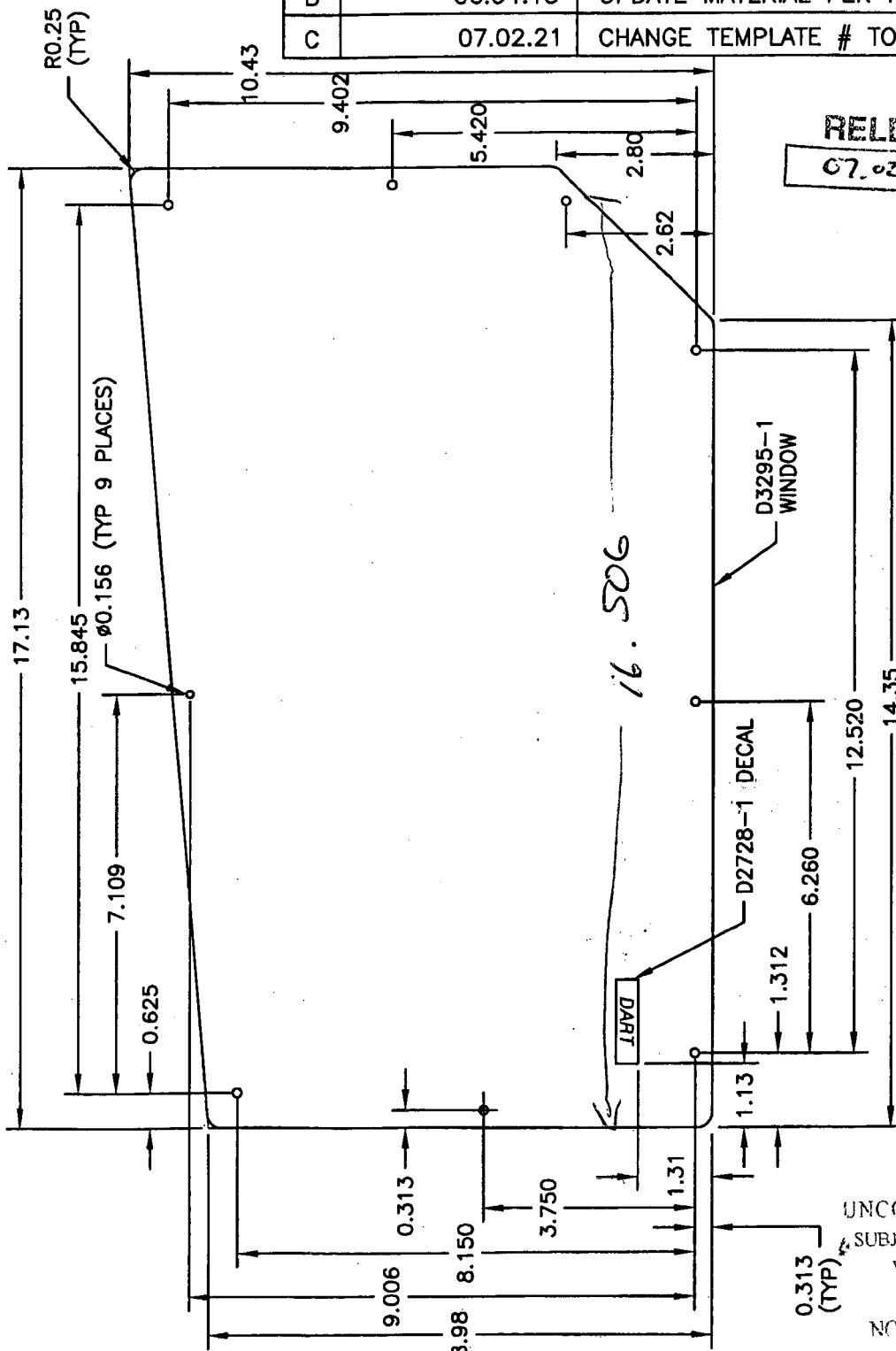
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY SSH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3295	REV. C SHEET 1 OF 1
DATE 07.02.21		TITLE FLOOR WINDOW	SCALE 1:3
A	04.06.28	NEW ISSUE	
B	06.04.13	UPDATE MATERIAL PER NCR 029	
C	07.02.21	CHANGE TEMPLATE # TO DT8822	

**D3295-041 FLOOR WINDOW**

- 1) CHECK DIMENSION WITH TEMPLATE DT8822
- 2) DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
- 3) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	33123
Description: FLOOR WINDOW	Part Number:	D3295-041
Inspection Dwg: D3295 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

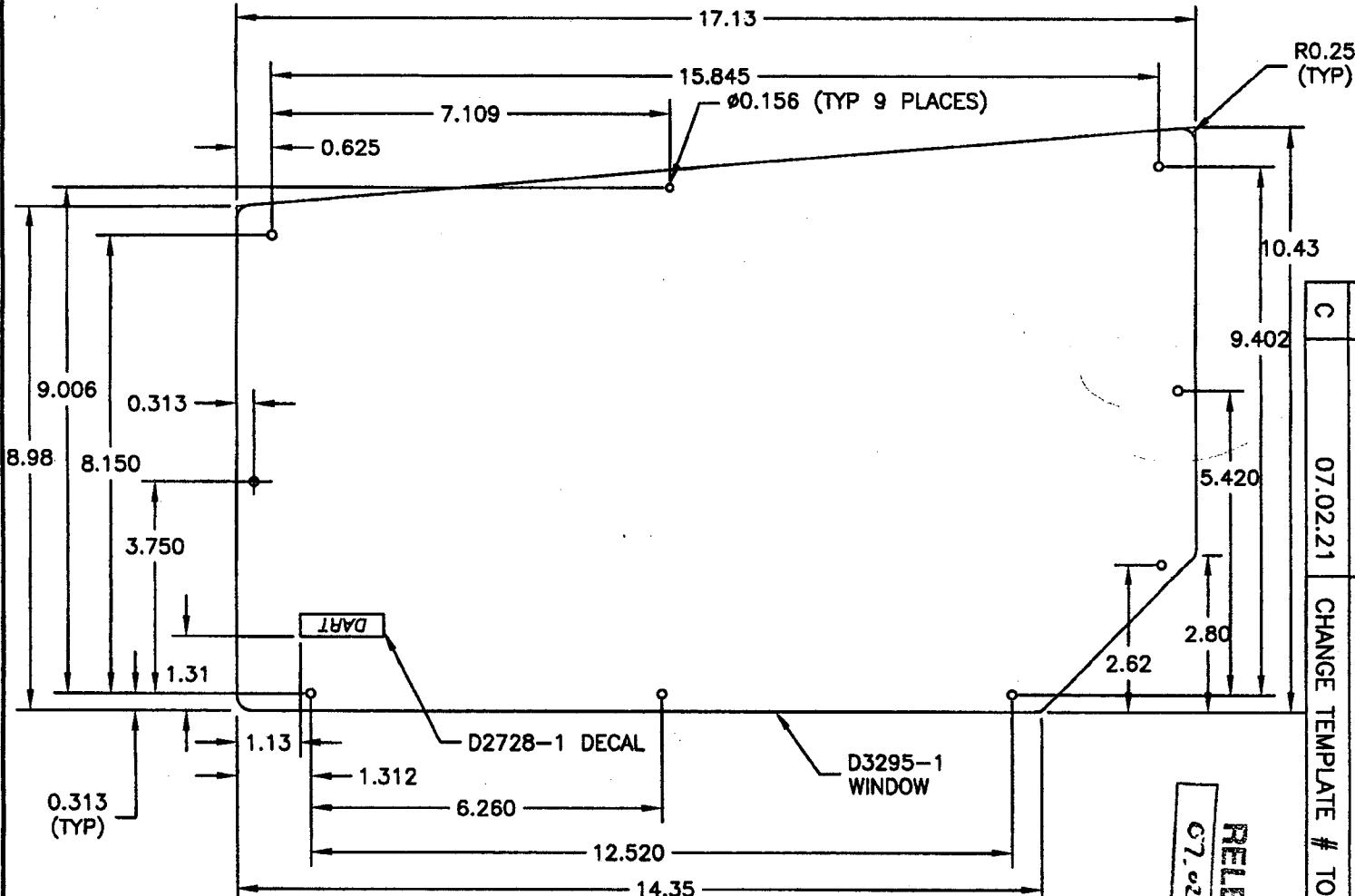
Measured by:	HB / <u>Pat</u>	Audited by:	En	Prototype Approval:	<u>1/4</u>
Date:	07-10-17	Date:	07/10/18	Date:	<u>1/4</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

D3295-041 FLOOR WINDOW

- 1) CHECK DIMENSION WITH TEMPLATE DT8822 
- 2) DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
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- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3295



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	SSH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3295
DATE		TITLE
07.02.21		FLOOR WINDOW
A	04.06.28	NEW ISSUE
B	06.04.13	UPDATE MATERIAL PER NCR 029
C	07.02.21	CHANGE TEMPLATE # TO DT8822
RELEASED		07.02.26
SHEET 1 OF 1		REV. C
		SCALE
		1:3